

CHG # 001

SHIP MAY 25

Work Order ID 132854

Tuesday, May 12, 2015 1:32:25 PM

132854

Page 1

Item ID: D119-796-021

Accept

N900040100

Setup Start

NS1

Revision ID: Assembly

Item Name: STD Landing Gear w/ STD Wearpads

Stop

NS2

Start Date: 5/12/15 Start Qty: 1.00

1

Cust Item ID:

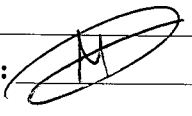
Required Date: 5/14/15 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: 

Date: 5-5-12 Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

IIN-D119-796	REV A
--------------	-------

100

Pick Kit

0.00

DAS

27

9-89

100

Packaging

Memo

0.00

Packaging

MAY 21 2015

110

0.00

110

HandFinish

Memo

0.00

Hand Finishing

ASSEMBLE AS PER DWG AND NOTES 8,9,10,11

2-INSTALL DECAL D2729-4

Procured 3/31/10 3131670

Exp Date 10/15

① SAG 15/05/22

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.00

Quality Control

DAS

9

9-89

① 15-05-25

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QS1042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER :					

Work Order ID 132854***132854***

Tuesday, May 12, 2015 1:32:25 PM

Page 2

Item ID: D119-796-021

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: STD Landing Gear w/ STD Wearpads

Stop ***NS2***Start Date: 5/12/15 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 5/14/15 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <i>Ship</i>	0.00							
130									
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

(Signature) 15.5.25*MWJ* MAY 25 2015*(Signature)* 15.5.25

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QS1042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Picklist Print

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Work Order ID: 132854

132854

Parent Item: D119-796-021

D119-796-021

Parent Item Name: STD Landing Gear w/ STD Wearpads

Start Date: 5/12/15

Required Date: 5/14/15

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A NEW ISSUE 15-05-012 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D119-646-041		Manufactured	No				Each	0.0000		2			
D119-646-041									**	SAD	19/05/21		
Replacement Skidtube with Wearpads, Fits LH or RH													
D119-796-151		Manufactured	No				Each	0.0000		1			
D119-796-151									**	SAD	15/05/21		
FWD Crosstube Installation with Step (no hardware)													
D119-796-251		Manufactured	No				Each	0.0000		1			
D119-796-251									**	SAD	15/05/21		
AFT Crosstube Installation with Step (no hardware)													
D2652		Manufactured	No				Each	428.0000		48			
D2652									**				
Bushing													

Location

Loc Qty

Loc Code

FG	29	
31985	29	
ST009	262	
129993	162	
131928	100	
ST012a	137	
123711	32	
124422	2	
129992	0	
131087	103	

DAB
27
9-89

MAY 21 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																						
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																						
Large Fab ☐	Composite ☐	Supplier ☐																							
Date :		Step #:		QTY Effective :			MRB (Q51042) Approval																		
Description Work Order Deviation				Disposition				Completed By																	
								Lead hand / Supervisor Approval Verification																	
								QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐																				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐																				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐																				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐																				
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Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐																				
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Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐																				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐																				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐																				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :																							
Misidentified ☐	Past Due ☐																								

Picklist Print

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Work Order ID: 132854

132854

Parent Item: D119-796-021

D119-796-021

Parent Item Name: STD Landing Gear w/ STD Wearpads

Start Date: 5/12/15

Required Date: 5/14/15

Start Qty: 1.00

Required Qty: 1.00

D3407-041

Manufactured No

Each

26.0000

2

D3407-041

Tow Ring

~~DA~~

27

~~9-89~~

Location

Loc Qty

Loc Code

st530

12

128380

12

ST532

14

107840

3

119184

2

130859

9

D3417-5

Manufactured No

Each

109.0000

4

D3417-5

Washer

~~DA~~

27

~~9-89~~

Location

Loc Qty

Loc Code

ST038

27

124382

1

128483

26

ST038A

82

129948

40

131054

42

D3456-1

Manufactured No

Each

100.0000

2

D3456-1

Washer

~~DA~~

27

~~9-89~~

Location

Loc Qty

Loc Code

FG

7

25701

7

ST051A

93

128456

3

129861

15

130974

50

132585

25

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Shop Packet Print

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Work Order ID: 132854

132854

Parent Item: D119-796-021

D119-796-021

Parent Item Name: STD Landing Gear w/ STD Wearpads

Start Date: 5/12/15

Required Date: 5/14/15

Start Qty: 1.00

Required Qty: 1.00

D3672-3

Manufactured No

Each

330.0000

48

D3672-3

**

DAB
27
9-89

Washer, Phenolic

LocationLoc QtyLoc Code

FG

105

127875

50

129916

40

84432

11

89273

4

FP001

14

107316

14

ST055

211

129916

211

Each

483.0000

48

D3672-7

Manufactured No

D3672-7

**

DAB
27
9-89

Washer, Phenolic

LocationLoc QtyLoc Code

ST055

483

120476

46

129987

437

Each

4.0000

2

D3883-1

Manufactured No

D3883-1

**

DAB
27
9-89

Saddle, Outboard LH

LocationLoc QtyLoc Code

ST404

4

128747

2

129416

2

B129064

2

MAY 21 2015

Picklist Print

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Work Order ID: 132854

132854

Parent Item: D119-796-021

D119-796-021

Parent Item Name: STD Landing Gear w/ STD Wearpads

Start Date: 5/12/15

Required Date: 5/14/15

Start Qty: 1.00

Required Qty: 1.00

D3883-2 Manufactured No

Each 12.0000 2

D3883-2

Saddle, Outboard RH

DAS
27
9-89

Location

Loc Qty

Loc Code

ST404

12

B127748

2

129065

12

D3884-1 Manufactured No

Each 1.0000 2

D3884-1

Saddle, Inboard LH

DAS
27
9-89

Location

Loc Qty

Loc Code

ST404

1

B129066

2

128748

1

D3884-2 Manufactured No

Each 12.0000 2

D3884-2

Saddle, Inboard RH

DAS
27
9-89

Location

Loc Qty

Loc Code

ST404

12

128746

1

B127624

2

129067

10

129415

1

D3886-041 Manufactured No

Each 26.0000 4

D3886-041

Lug Assembly

DAS
27
9-89

Location

Loc Qty

Loc Code

st529

26

122357

2

124454

10

130027

4

130512

10

MAY 21 2015

Picklist Print

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Work Order ID: 132854

132854

Parent Item: D119-796-021

D119-796-021

Parent Item Name: STD Landing Gear w/ STD Wearpads

Start Date: 5/12/15

Required Date: 5/14/15

Start Qty: 1.00

Required Qty: 1.00

AN3C46A

Purchased

No

Each

239.0000

8

AN3C46A

Bolt

~~DAE~~
27
~~9-89~~

Location

Loc Qty

Loc Code

FG	10	
122843	10	
FP001	8	
M128491	8	
ST338a	187	
131651	70	
<u>M131856</u>	47	
M132169	70	
ST346	34	
M130796	12	
M131367	22	

8

AN3C50A

Purchased

No

Each

132.0000

16

AN3C50A

Bolt

~~DAE~~
27
~~9-89~~

Location

Loc Qty

Loc Code

ST338a	72	
131651	24	
M131367	24	
M132169	24	
ST346	60	
M128491	16	
M131263	20	
<u>M131856</u>	24	

16

MAY 21 2015

Picklist Print

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Work Order ID: 132854

132854

Parent Item: D119-796-021

D119-796-021

Parent Item Name: STD Landing Gear w/ STD Wearpads

Start Date: 5/12/15

Required Date: 5/14/15

Start Qty: 1.00

Required Qty: 1.00

AN4C6A

Purchased

No

Each

466.0000

24

AN4C6A

Bolt

DAs

27

9-89

Location

Loc Qty

Loc Code

FG

14

103344

4

121657

10

ST312A

200

m131618

200

ST345

252

m130716

52

m131410

200

MS21043-3

Purchased

No

Each

741.0000

24

MS21043-3

Nut

DAs

27

9-89

Location

Loc Qty

Loc Code

FG

80

103691

80

FP001

41

m130673

41

GA

315

m130673

15

m131677

300

ST304

305

m131340

305

MAY 21 2015

Picklist Print

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Work Order ID: 132854

132854

Parent Item: D119-796-021

D119-796-021

Parent Item Name: STD Landing Gear w/ STD Wearpads

Start Date: 5/12/15

Required Date: 5/14/15

Start Qty: 1.00

Required Qty: 1.00

MS21043-4

Purchased

No

Each

599.0000

26

MS21043-4

Nut

Location

Loc Qty

Loc Code

FG

40

104603

40

GA

326

m128798

326

ST304

233

m128818

34

m131697

199

Each

202.0000

8

DAB

27

9-89

MS21043-5

Purchased

No

Each

202.0000

8

MS21043-5

Nut

Location

Loc Qty

Loc Code

FG

20

101418

20

GA

77

116548

77

ST304

105

m131317

5

m132123

100

Each

0.0000

8

DAB

27

9-89

MS21250-05048

Purchased

No

Each

0.0000

8

MS21250-05048

BOLT

m132317

DAB

27

9-89

MAY 21 2015

Picklist Print

Tuesday, May 12, 2015 1:32:31 PM

Work Order ID: 132854

132854

Parent Item: D119-796-021

D119-796-021

Parent Item Name: STD Landing Gear w/ STD Wearpads

Start Date: 5/12/15

Required Date: 5/14/15

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0332R

Purchased

No

Each

2,833.000

24

NAS1149C0332R

DAS

WASHER

27

9-89

Location

Loc Qty

Loc Code

FP001

2140

m130325

2140

GA

606

m131618

606

ST260a

87

m131697

87

Each

2,813.000

48

NAS1149C0432R

Purchased

No

NAS1149C0432R

DAS

WASHER

27

9-89

Location

Loc Qty

Loc Code

GA

2150

m125807

476

m131467

1674

ST271

663

m131452

663

Each

340.0000

16

NAS1149C0532R

Purchased

No

NAS1149C0532R

DAS

WASHER

27

MAY 27 2015

Location

Loc Qty

Loc Code

GA

62

116513

62

ST271

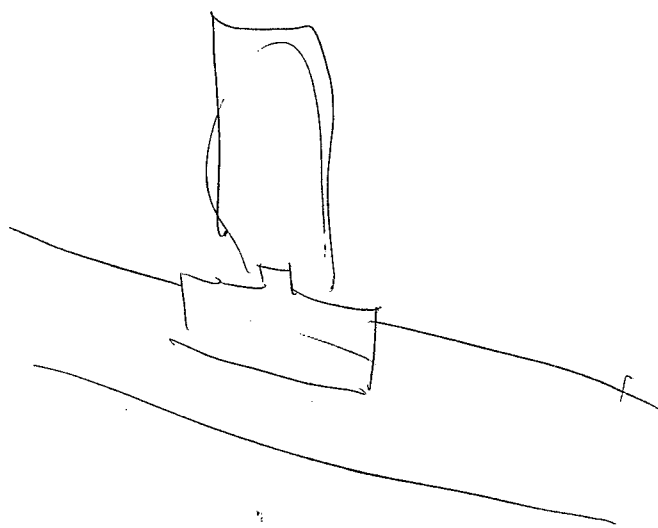
278

m128537

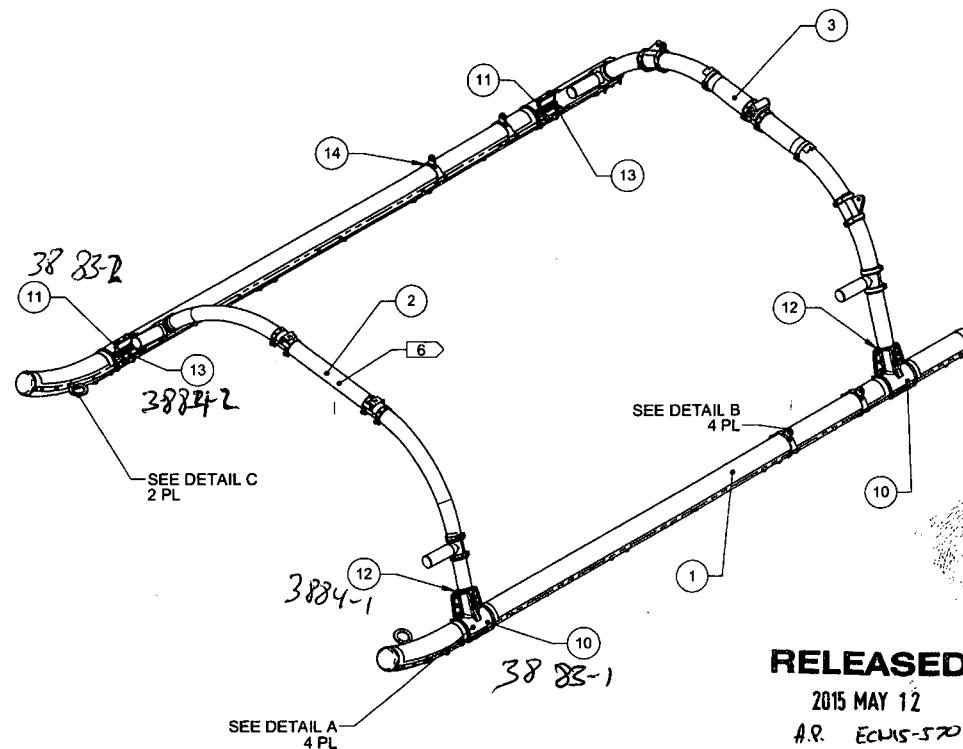
78

m131624

200



ITEM	QTY	P/N	DESCRIPTION
	X	D119-796-021	STD GEAR WITH STD WEARPADS
1	2	D119-646-041	STD SKIDTUBE WITH STD WEARPADS
2	1	D119-796-151	XTUBE ASSY (AW119 MKII FWD)
3	1	D119-796-251	XTUBE ASSY (AW119 MKII AFT)
4	48	D2652	BUSHING
5	2	D3407-041	TOW RING
6	4	D3417-5	WASHER
7	2	D3456-1	WASHER
8	48	D3672-3	PHENOLIC WASHER
9	48	D3672-7	PHENOLIC WASHER
10	2	D3883-1	SADDLE, OUTBOARD LH
11	2	D3883-2	SADDLE, OUTBOARD RH
12	2	D3884-1	SADDLE, INBOARD LH
13	2	D3884-2	SADDLE, INBOARD RH
14	4	D3886-041	LUG ASSEMBLY
15	8	AN3C46A	BOLT
16	16	AN3C50A	BOLT
17	24	AN4C6A	BOLT
18	24	MS21043-3	NUT, SELF-LOCKING
19	28	MS21043-4	NUT, SELF-LOCKING
20	8	MS21043-5	NUT, SELF-LOCKING
21	8	MS21250-05048	BOLT
22	24	NAS1149C0332R	WASHER
23	48	NAS1149C0432R	WASHER
24	16	NAS1149C0532R	WASHER



RELEASED

2015 MAY 12

A.P. ECMS-570

D119-796-021 STD GEAR WITH STD WEARPADS

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: N/A
- 4) UNITS: N/A
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: INSTALL D2729-4 RED DECAL IN LOCATION SHOWN
- 7) WEIGHT: 122.7 LBS

Handwritten: 15.05.20
132854

APPROVED

A	NEW ISSUE	AP	15.04.01
REV.	DESCRIPTION	BY	DATE
DESIGN	AP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AP		
CHECKED	AJS	DRAWING NO.	REV. A
MFG. APPR.	DD	D119-796-021	SHEET 1 OF 4
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	STD GEAR WITH STD WEARPADS	NTS
DATE	15.04.01	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

MS21250-05048 BOLT
NAS1149C0532R WASHER
D3672-7 WASHER
2 PL
10

D3883-1 SADDLE (LHS)
D3883-2 SADDLE (RHS)

D3884-1 SADDLE (LHS)
D3884-2 SADDLE (RHS)

D3672-7 WASHER
NAS1149C0532R WASHER
MS21043-5 NUT
2 PL
10

D2652 BUSHING
D3672-7 WASHER
NAS1149C0332R WASHER
MS21043-3 NUT
4 PL
10

DETAIL A
4 PL



AN4C6A BOLT
NAS1149C0432R WASHER
D3672-3 WASHER (2)
NAS1149C0432R WASHER
MS21043-4 NUT
6 PL
9

D3883-1 SADDLE (LHS)
D3883-2 SADDLE (RHS)
REF

DETAIL A



NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: N/A
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) APPLY A CONTINUOUS BEAD OF SIKAFLEX -241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT IN THE LOCATIONS SHOWN INCLUDING THE FOLLOWING:
 - A) ALONG SADDLE/CROSSTUBE INTERFACE
 - B) BETWEEN THE SADDLE FLANGES
 - C) ALONG SADDLE/SKIDTUBE INTERFACE
- 9) LIGHTLY TIGHTEN ALL BOLTS IN THE NUMERICAL ORDER SPECIFIED ON SHEET 3, THEN TIGHTEN TO SPECIFIED TORQUE IN TABLE 1.
- 10) INSTALL WET WITH SIKAFLEX -241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT
- 11) ALL NUTS TO BE INSTALLED ON THE INBOARD SIDE

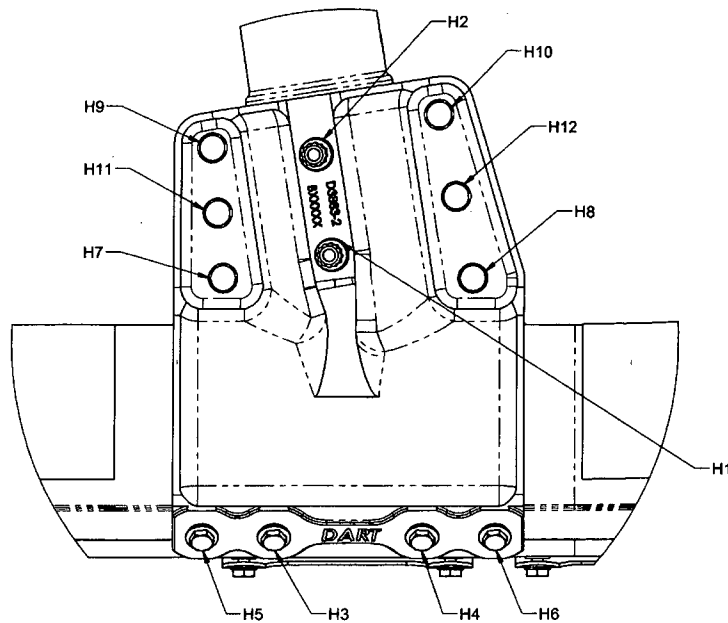
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2015 MAY 12

A.P. EEW 15-570

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DRAWN	AP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AJS	DRAWING NO.	REV. A
MFG. APPR.	DD	D119-796-021	SHEET 2 OF 4
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	STD GEAR WITH STD WEARPADS	NTS
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SUPPLEMENTAL VIEW - TORQUE SEQUENCE

TABLE 1: TORQUE SEQUENCE AND MAX TORQUE

TORQUE SEQUENCE	PART NUMBER	TORQUE
H1	MS21250-05048	66-85 IN-LBS (7.3 - 9.6 n-m)
H2	MS21250-05048	66-85 IN-LBS (7.3 - 9.6 n-m)
H3	AN3C50A	15-25 IN-LBS (1.7 - 9.6 N-m)
H4	AN3C50A	15-25 IN-LBS (1.7 - 9.6 N-m)
H5	AN3C50A	15-25 IN-LBS (1.7 - 9.6 N-m)
H6	AN3C50A	15-25 IN-LBS (1.7 - 9.6 N-m)
H7	AN4C6A	50-70 IN-LBS (5.7 - 7.9 N-m)
H8	AN4C6A	50-70 IN-LBS (5.7 - 7.9 N-m)
H9	AN4C6A	50-70 IN-LBS (5.7 - 7.9 N-m)
H10	AN4C6A	50-70 IN-LBS (5.7 - 7.9 N-m)
H11	AN4C6A	50-70 IN-LBS (5.7 - 7.9 N-m)
H12	AN4C6A	50-70 IN-LBS (5.7 - 7.9 N-m)

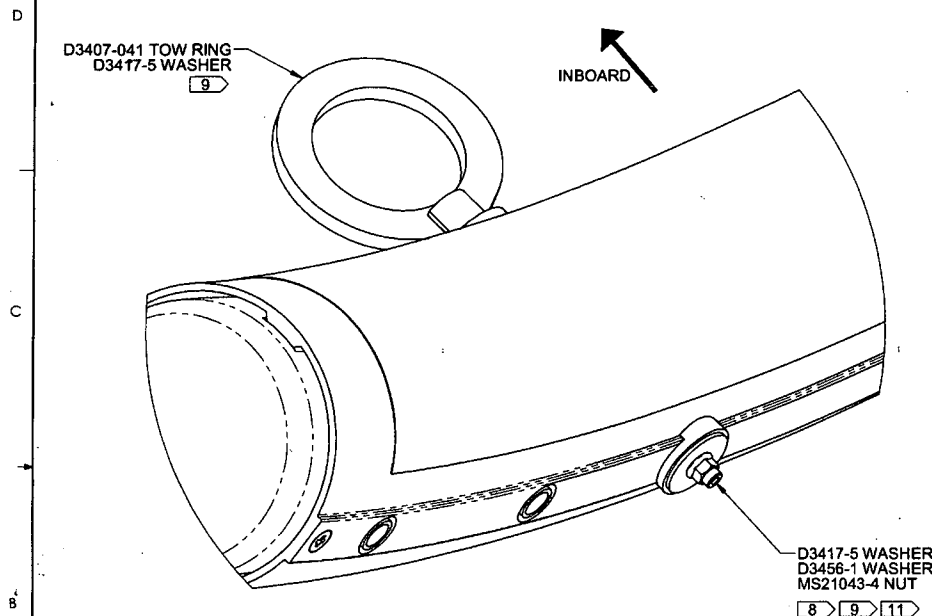
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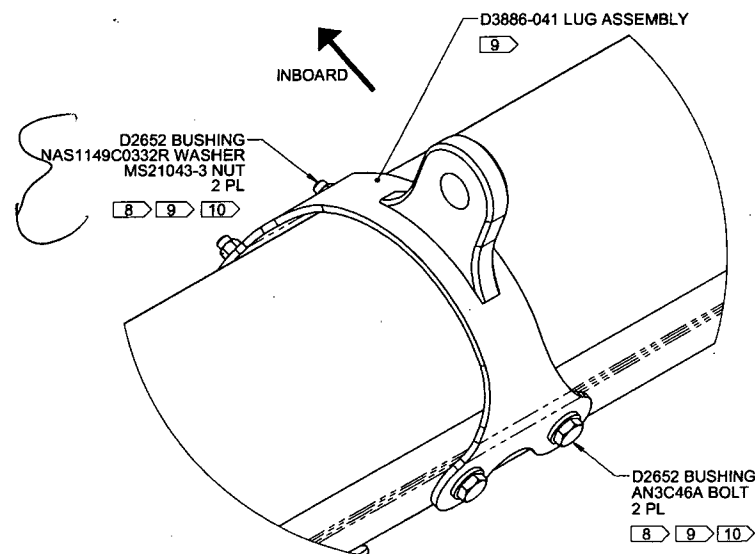
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MFG. APPR.	DD	D119-796-021	SHEET 3 OF 4
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8 7 6 5 4 3 2 1



DETAIL C
2 PL



DETAIL B
4 PL

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2015 MAY 12

A.R. EN15-570

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: N/A
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) INSTALL WET WITH SIKAFLEX -241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT
- 9) APPLY FAY SEAL AND FILLET SEAL USING SIKAFLEX -241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT
- 10) TORQUE AN3 HARDWARE TO 20-25 IN-LBS
- 11) TORQUE AN4 HARDWARE TO 50-70 IN-LBS

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8 7 6 5 4 3 2 1